



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-013
Job Sheet 174379



Part No: D412-698-013

Job Qty: 2 ea

Part Name: Cabin Door Handle - Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/14/18

Job Tracking No:

Due Date: 3/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev: C Removed Manufacturing 05-11-06 JLM IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/30/18	3/30/18	0.00	0.00	Start Up Stores/Pkg-2	2.48	MAR 15 2018
110	Packaging	2 pcs	3/30/18	3/30/18	0.00	0.00	Packaging1-4	8.89	MAR 15 2018
120	QC	2 pcs	3/30/18	3/30/18	0.00	0.00	QC4	9.00	
125	DC	2 pcs	3/30/18	3/30/18	0.00	0.00	DC		
130	Packaging	2 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3-2		
140	QC21-FG	2 Ea	3/30/18	3/30/18	0.00	0.00	QC21	21	MAR 16 2018

Part Op 125 - Photocopy bluefile and create labels per PPP D412-698-013 CHG001
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3203-1	Handle	8 Ea (4 ea)	90-Start up Operation	
D3220-041	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	
D3220-042	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	
D3220-3	Doubler	4 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	
MS24694-S98	Screw	32 Ea (16 ea)	90-Start up Operation	
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3203-1	8	12	0
	D3220-041	2	7	0
	D3220-042	2	4	0
	D3220-3	4	12	0
	MS21042L4	16	3,314	0
	MS24694-S98	32	86	0
	NAS1149D0463J	16	4,382	0

001701

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐																																																					
Date : _____		#: _____		QTY Effective : _____			MRB (QSI042) Approval																																																		
er Deviation		Disposition						Completed By																																																	
Lead hand / Supervisor Approval Verification								QC / QA Coordinator Approval																																																	
FAULT CATEGORY <table border="0"> <tr> <td>☐ Environment</td> <td>☐ Pressure/Forced</td> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Design</td> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Doc/Data</td> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Equip/Tooling</td> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Handling/Pre</td> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Material</td> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Internal Transport</td> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Tribal Knowledge</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ LOA</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Substation</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Environment	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Design	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Doc/Data	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Equip/Tooling	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Handling/Pre	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Material	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Internal Transport	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Tribal Knowledge	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ LOA	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Substation	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	OTHER : _____					
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DART
AEROSPACE

Container No: S051894

Part: D412-698-013

Job No: 174379

Serial No/Batch: S051894

Revision: G

Inspector:

Date: 03/15/18

Part Specifications
Specifications could not be found.

Plex 3/14/18 2:48 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001701	S051807	D3203-1	Handle	S038295	ST484	8
001701	S051810	D3220-041	Doubler Assembly	S035718	ST485	2
001701	S051808	D3220-042	Doubler Assembly	S042344	ST485	2
001701	S051809	D3220-3	Doubler	S035720	ST485	4
001701	S051890	MS21042L4	Nut	S045901	ST303	16
001701	S051888	MS24694-S98	Screw	FM135704-0	ST283	32
001701	S051887	NAS1149D0463J	Washer	S045845	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/15/18 2:30 PM dart.quirion.sonia

6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW